

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012758**Date Inspected:** 20-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Chi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress:

Segment # 7AE-PP48

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG033A-004; The Critical Welding Repair Report (CWRR) was B-CWR1212. ZPMC QC is identified as Mr. Wang Jian. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. See the attached Below Photo.

Segment # 7CE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048047 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA039-004; The Welding Repair Report (WRR) was B-WR1227. ZPMC QC is identified as Mr. Sun Bai Zheng. The welding parameters measured using QC's calibrated

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Segment# 7AE

During in process visual inspection of 7AE , This QA Inspector observed ZPMC Quality Control (QC) personnel performing Magnetic Particle testing (MT) ZPMC Technician identified as Mr. Fu Zhi Qiang, of the Longitudinal Diaphragm 16 A W3 Location for more comprehensive information refer the attached Photo.

Segment# 7AE

This QA inspector observed, ZPMC qualified welding personnel identified as 037932 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA033-006; ZPMC CWI is identified as Mr. Wu Chi Cheng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1

Segment# 7BW-7CW

This QA inspector observed, ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW-009; ZPMC CWI is identified as Mr.Zhang Hai Tao. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Miller,Mark

QA Reviewer